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INVENTOR: JOHN H. JAKSCH

TITLE: TABBER APPARATUS AND METHOD

ATTORNEY: CARDINAL LAW GROUP
1603 ORRINGTON SUITE 2000
EVANSTON, IL 60201
(847) 905-7111

TABBER APPARATUS AND METHOD

PRIORITY

5 This application claims priority as a divisional application to U.S. Patent Application Ser. No. 09/523,400, filed March 10, 2000, which claims priority as a divisional application to U.S. Patent Application Ser. No. 09/110,093, filed July 2, 1998, now United States Patent number 6,090,034 granted July 18, 2000. Both applications are incorporated herein by reference

10 FIELD OF THE INVENTION

The invention generally relates to the field of tabbing machines which seal an open edge of folded or multipage media with adhesive backed tabs.

BACKGROUND OF THE INVENTION

15 In general, tabbing machines are used to affix adhesive backed tabs over the open edges of media, which are commonly used in bulk rate mailers. Typically, these tabbing machines include rollers which feed a single form or media from the bottom of a stack of media with driven rollers toward a tab dispensing area. The open edge of the media is driven against the tab and the tab is folded over the open edge and onto the sides of the media with additional
20 rollers.

One problem encountered with such tabbing machines results from the variable pressure sensitivity of the rolls of adhesive backed tabs due to, for example, the age of the tabs and other physical properties. These tabbing machines may not be capable of dispensing a wide variety of shapes and sizes
25 of tabs which are necessary for the wide variety of shapes and sizes media. It is also important to properly place the tab over the edge so that the tab is preferably secured equally to each side of the media. It would be desirable to

have a tabbing machine which could be easily adjusted to take into account the pressure sensitivity of the tabs, the size of the tabs, and the positioning of the tabs on the media.

5 Another problem encountered in existing tabbing machines is the tendency of the opposing rollers, which are used to fold the tab and which are typically made of rubber or plastic, to grip the tab prior to the tab entering a nip region between the opposing rollers. This gripping action may result in the improper placement of the tab on the media. It would be desirable to have a
10 folding roller system which prevents such gripping.

 Existing tabbing systems may also include roller shafts which are permanently attached to the frame, and accordingly make it difficult to clear jams. In addition, roller pairs are used to take-up the backing paper when dispensing a tab. Moreover, existing tabbing systems have inefficiencies due to the additional
15 horsepower necessary to drive the variable load of tabs on the tab reel. These systems must be sized with motors and tab reel brakes to handle the condition when the tab reel has a full load, for example, a roll of 5000 tabs. Accordingly, it would be desirable to have an efficient, low-cost system which solves the problems described above.

20 SUMMARY OF THE INVENTION

 One aspect of the invention provides a tabber apparatus comprising of a frame, friction drive roller rotatably and operatively connected to the frame, a take-up spool rotatably and operatively connected to the frame and operatively
25 connected to the friction drive roller to allow backing paper which is wrapped about a portion of the friction drive roller to be taken up onto the the take-up spool. The apparatus may further comprise a guide post positioned to allow the portion of the friction drive roller to be wrapped with the backing paper. The wrap may cover at least about 60 degrees of the friction drive roller and preferably 100

to 180 degrees of the friction drive roller. The friction drive roller preferably comprises a sponge-like material, for example, neoprene. The apparatus may further include a tab folding roller assembly comprising a tab drive roller made of a slick material, for example, aluminum.

A further aspect of the invention provides a method of operating a tabber apparatus. A friction drive roller rotatably and operatively connected to the frame, and a take-up spool rotatably and operatively connected to the frame and operatively connected to the friction drive roller are provided. The backing paper is wrapped around a portion of the friction drive roller. The friction drive roller is rotated. The take-up spool is rotated, and the backing paper is taken up on the take-up spool. The backing paper may be wrapped preferably between at least about 100 to 180 degrees around the friction drive roller. A peel plate may be provided, and the backing paper may be pulled a first distance around the peel plate to partially peel one adhesive back tab from the backing paper. The friction drive roller may be rotated to pull the backing paper a first distance. The take-up spool may be rotated more than the first distance to provide tension in the backing paper. A tab folder roller assembly including a tab drive roller with a slick surface may be also provided. A leading edge of a form may contact the adhesive back tab so that the tab is gripped in a nip region formed between the slick tab drive roller and a tab pressure roller.

A further aspect of the invention provides a tabber apparatus comprising a frame, a tab reel spindle rotatably connected to the frame, a brake member including a brake link rotatably attached to the frame at an axis point, and a roller rotatably attached to the brake link, wherein the roller is rotated from a first position to a second position about the axis point when a tab is dispensed, and returns to the first position while pulling a backing paper from the tab reel spindle. Preferably, a brake link O-ring positioned around the brake link adjacent an end of the brake link allows the brake link O-ring to press against the spindle when in

the first position. A spindle O-ring may also be preferably positioned around the spindle so that the spindle O-ring contacts with the brake link O-ring when in the first position. Preferably, the brake link has a length and the roller has a weight
5 sufficient to allow the brake member to stop the spindle from rotating when the roller is in the first position, and to rotate the spindle when rotating the roller from the second position to the first position. Preferably, the first position of the roller is lower than the second position of the roller.

A further aspect of the invention provides a method of operating a tabber
10 apparatus. A frame, a reel spindle rotatably connected to the frame, a brake member including a brake link rotatably attached to the frame at an axis point, and a roller rotatably attached to the brake link are provided. The brake link member is rotated about the axis to move the roller from a first position to a second position when a tab is dispensed. The brake member is rotated to move
15 the roller back to the second position. The backing paper is pulled from the tab reel spindle with the roller as it moves from the second position to the first position. A first end of the brake link is preferably pressed against the spindle when the roller is in the first position to stop rotation of the spindle. A first O-ring is preferably positioned around the brake link and a second O-ring is preferably
20 positioned around the spindle. The first and second O-rings contact each other to stop the spindle from rotating when the roller is in the first position.

A further aspect of the invention provides a tabber apparatus comprising a frame including a top panel, the top panel including a media sensor opening and a tab sensor opening formed therein, a media sensor positioned adjacent the
25 media sensor opening, a microcontroller operatively connected to the media sensor and to the tab sensor, and a motor operatively connected to the microcontroller wherein the microcontroller receives signals from the media sensor and tab sensor and activates and deactivates the motor to dispense tabs. Preferably, the tab sensor and media sensor are reflective, modulated optical
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sensors. Preferably, the media sensor is positioned up stream of the tab sensor. The apparatus may further comprise EEPROM operatively connected to the microcontroller to allow input by an operator to control the amount of tab peel.

5 A further aspect of the invention provides a method of operating a tabber apparatus. A frame including a top panel is provided. The top panel includes a media sensor opening and a tab sensor opening formed therein. The media sensor is positioned adjacent the media sensor opening and the tab sensor is positioned adjacent the tab sensor opening. A microcontroller is operatively
10 connected to the media sensor and the tab sensor, and a motor is operatively connected to the microcontroller. Signals sent by the media sensor and tab sensor are received by the microcontroller. The motor is activated and deactivated to dispense tabs in timed sequence. Upon receipt of a signal by the microcontroller from the media sensor, a tab may be partially peeled from a
15 backing paper. The tab dispense may be completed upon sending a signal from the tab sensor to the microcontroller. EEPROM may be operatively connected to the microcontroller. The amount of peel may be controlled by programming the time of motor activation. A first media may be transported toward a first tab which is fully dispensed. The media sensor is then blocked with the first media.
20 A delay timer for a pre-dispense cycle is then started. The first tab is then pulled from the backing paper. The tab sensor is then blocked with reflective light from the first media. A pre-dispense cycle of a second tab is started. The media sensor and tab sensor are unblocked as a trailing edge of the first media clears the sensor openings. The dispense cycle of the second tab is started by turning
25 on the motor. The tab sensor is then blocked with the second tab and the motor is then stopped.

A further aspect of the invention provides a tabber apparatus comprising a frame including at least one opening formed therein, a removable shaft including an end received in the opening, a retaining member including a body portion and a first arm portion rotatably attached to the frame, and a second portion biased to allow contact of the body portion against the shaft to retain the shaft in the opening. The shaft preferably includes a notch formed therein to receive the body portion of the retaining member. The second arm portion may be biased with a spring, which is attached at a first end to the second arm portion and at a second end to the frame. Preferably, a retaining member may contact the shaft adjacent both of the shaft ends. The frame may also include openings wherein the first and second arm portions extend through the openings. The arm portions may include openings therein to allow insertion of a locking pin.

A further aspect of the invention provides a method of operating a tabber apparatus. A frame including at least one opening formed therein, a removable shaft including an end received in the opening, and a retaining member including a body portion and first and second arm portions, with the first arm portion rotatably attached to the frame, is provided. The second arm portion is biased. The body portion is contacted against the shaft. The shaft is retained within the opening. The body portion may be biased against the shaft by use of a spring attached to the second arm and to the frame. The body portion may be received in a notch formed in the shaft. The retaining member may be rotated about the first arm portion to remove the shaft from the opening.

The foregoing and other features and advantages of the invention will become further apparent from the following detailed description of the presently preferred embodiments, read in conjunction with the accompanying drawings. The detailed description and drawings are merely illustrative of the invention rather than limiting, the scope of the invention being defined by the appended claims and equivalents thereof.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a preferred embodiment of a tabber apparatus made in accordance with the invention;

5 **FIG. 2** is a partial exploded view of a preferred embodiment of a tabber apparatus made in accordance with the invention;

FIG. 3 is a sectional view of a preferred embodiment of a tabber apparatus in operation;

10 **FIG. 4** is the roller drive side of a preferred embodiment of a tabber apparatus made in accordance with the invention;

FIG. 5 is the media drive side of a preferred embodiment of a tabber apparatus made in accordance with the invention;

FIG. 6 is a waveform diagram showing a preferred embodiment of the sequencing of the tabbing process;

15 **FIG. 7** is a plan view of a preferred embodiment of a retaining member and pressure roller shown in operating position;

FIG. 8 is an end view of the retaining member of **FIG. 7**;

FIG. 9 is a plan view of the retaining member of **FIG. 7**;

FIG. 10 is a side view of a retaining member including a 20 degree bend;

20 **FIG. 11** is a perspective view of a preferred embodiment of a brake roller;

FIG. 12 is an end view of the brake roller of **FIG. 11**;

FIG. 13 is a plan view of the brake roller of **FIG. 11**;

FIG. 14 is a front view of a preferred embodiment of a tab reel brake link;

FIG. 15 is a side view of the tab reel brake link of **FIG. 14**;

25 **FIG. 16** is a side view of a preferred embodiment of a friction drive roller;

FIG. 17 is an end view of the friction drive roller of **FIG. 16**;

FIG. 18 is a side view of a preferred embodiment of a take-up spool;

FIG. 19 is an end view of a preferred embodiment of the take-up spool of **FIG. 18**;

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FIG. 20 is a side view of a preferred embodiment of a tab reel spindle;

FIG. 21 is an end view of the tab reel spindle of **FIG. 20**;

FIG. 22 is a wiring diagram for a preferred embodiment of the tabber apparatus; and

FIG. 23 is a plan view of a preferred embodiment of the top panel showing the media sensor opening and tab dispenser sensor opening.

DETAILED DESCRIPTION OF THE PRESENTLY PREFERRED EMBODIMENTS

Referring to **FIGS. 1-3**, a preferred embodiment of the tabber apparatus **100** includes a feed roller assembly **110**, a drive roller assembly **112**, and a tab folding roller assembly **114**, each of which is operatively connected to housing **116**. Media **90** is transported by the feed roller assembly **110** to the drive roller assembly **112**. Tabs **81** are rotated into position and partially peeled from the backing paper **82** by the tab dispensing assembly **118**. The drive roller assembly **112** forces the media **90** into the partially peeled tab **81a**. Media **90** is carried into the folding roller assembly **114** where the tab **81b** is secured to the media and the media **90** exits from the tabber apparatus **100**. A preferred embodiment of the tabber apparatus is, for example, the EX5100 Express Tabber, available from Martin Yale Industries, Inc., Wabash, Indiana 46992.

Referring to **FIGS. 1, 2 and 4**, the feed roller assembly **110** preferably includes a plurality of spaced apart feed rollers **5** which are attached to feeder shaft **46**. Preferably, the feed rollers **5** are grooved to facilitate the transport of the media **90**. The feeder shaft **46** is preferably made of steel, and the feed rollers **5** are preferably made of rubber, or rubber-like material. The drive roller assembly **112** preferably includes a drive shaft **45** having a plurality of spaced apart drive rollers **6**, and a removable upper mid-shaft **4** having spaced apart drive pressure rollers **25**. The drive shaft **45** and upper mid-shaft **4** are preferably made of steel, the drive rollers **6** are preferably made of a rubber-like

material, and the drive pressure rollers **25** are preferably made of plastic. The exit shaft **44** and upper exit shaft **36** are preferably made of steel, and the tab rollers **6** are made of rubber-like material. The folding roller assembly **114**

5 preferably includes an exit shaft **44** having a tab drive roller **7** positioned between and spaced apart from a pair of drive rollers **6**, and a removable upper exit shaft **36** having a tab pressure roller **29** attached between and spaced apart from a pair of drive pressure rollers **25**. The tab drive roller **7** is preferably made of a material having a slick surface with a low co-efficient of friction such as, for

10 example, aluminum. The slick surface prevents the tab **81** from being prematurely gripped prior to entering the nip region **75** between the tab pressure roller **29** and tab drive roller **7**. The feed shaft **46** is driven by an electric drive motor **38** through a media drive motor pulley **32**, a timing belt **48**, a combo pulley **11**, a timing belt **49**, and a feed drive pulley **31**, which is connected to the feeder shaft **46**. A suitable motor **38** may be, for example, a 24 Volt DC Motor. For

15 example, the timing belt **48** may be a 95T Timing Belt, the timing belt **49** may be a 211T Timing Belt, the media drive motor pulley **32** may a 10T Motor Pulley, and the feed drive pulley **31** may be a 72T Feed Drive Pulley. Media drive pulleys **12** are driven by a timing belt **49** and an idler pulley **14** at an increased speed to the feed drive pulley **31**. One of the media drive pulleys **12** is attached to the drive shaft **45** and another media drive pulley **12** is attached to the exit shaft **44**. The media drive pulley **12** may, for example, be a 40T Media Drive Pulley.

20 Accordingly, when the form or media **90** contacts the drive roller assembly **112**, each form is spaced from the trailing form to allow adequate time for the tab dispensing and tab folding functions.

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Referring to **FIGS. 1-3**, and **5**, the tab dispensing assembly **118** may preferably include a tab dispensing mounting frame **21** having a tab reel spindle post **55** mounted thereto, a tab reel spindle **19**, and tab reel and hub guides **56**. The hub guides **56** retain a roll **80** of adhesive backed tabs **81** which are applied to backing paper **82**. A typical roll may, for example, include 5000 tabs. The mounting frame **21** and spindle post **55** are preferably made of steel. The spindle **19** and hub guides **56** are preferably made of plastic. As shown in **FIGS. 20, 21**, the spindle **19** may preferably include at least one notch **175**, which receives O-ring **129** (See **FIG. 3**). The roll of tabs **80** slide onto the spindle **19**. The tab dispensing assembly **118** further includes a tab brake **130** comprising a tab reel brake link **57** rotatably attached to the mounting frame **21** and to a reel brake post **34** with a rotatable tab brake roller **58**. In addition, the tab dispensing assembly **118** may preferably include a rotatably mounted backing tape take-up spool **20**, spool guide posts **59** with guide spools **50**, and a carrier drive shaft **23** with tab carrier friction drive roller **60**. As shown in **FIGS. 16-17**, the tab carrier friction drive roller **60** may preferably be made, for example, with an aluminum core **145** and with a foam sleeve such as, for example, a neoprene sponge. The friction drive roller may have a length of 1.75 inches and a diameter of 1.25 inches. The brake link **57**, bar post **34**, tab brake roller **58**, spool guide posts **59** and drive shaft **23** are preferably made of steel. As shown in **FIGS. 11-13**, the tab brake roller **58** may, for example, have a length of 2.10 inches, a diameter of 1.0 inch, and be made of 1 $\frac{1}{2}$ inch aluminum. As shown in **FIGS. 14-15**, the brake link **57** may, for example, have a length of 5.50 inches, and a width of 0.75 inch, and an axis opening **156** spaced (center to center) 4.20 inches from tab brake roller opening **158**. The center of the openings **156**, **158** are positioned 0.25 inch from the side of the brake link **57**. A grooved region or notch **155** may be positioned, for example, 0.364 inches from the adjacent end of the brake link **57**, and receives O-ring **128**. (See **FIG. 3**). The take-up spool **20** and guide spools

50 are preferably made of plastic. As shown in FIGS. 18, 19, the spindle 19 may have a length of 2.5 inches, a diameter of 1.0 inch and a groove 165 formed adjacent one end for receiving an O-ring belt 167 (See FIG. 3). The spindle also includes slit 166 to receive backing paper 82. The guide rollers 50 and friction drive roller 60 are positioned to provide a degree of wrap around the friction drive roller 60 which eliminates the need for a pressure roller. The degree of wrap is preferably at least about 60 degrees, but more preferably at least about 100-180 degrees around the friction drive roller 60. A preferred embodiment includes approximately a 180 degree wrap, that assures a positive drive. The friction drive roller 60 is driven by an electric motor 38a, a motor pulley 32a, a timing belt 53, and a tab drive pulley 37. The motor 38a may, for example, be a 24 Volt DC motor. The motor pulley 32a may be a 10T Motor Pulley and the tab drive pulley 37 may, be a 60T Tab Drive Pulley. Tab drive pulley 37 is connected to the carrier drive shaft 23. A tab peel plate 17 is also attached to the mounting frame 21 with mounting bar assembly 18 and to the guide mounting cross bar 27 with peel bar support 72. The peel support 72 aids in preventing bending of the tab peel plate 17. The peel plate 17, mounting bar assembly 18, peel bar support 72, and guide mounting cross bar 27 are preferably made of steel. A tab fold guide bracket 51 may also be removably fastened to the mounting bar assembly 18. The tab fold guide bracket 51 are preferably made of plastic.

Referring to FIG. 2, other features and components of the tabber apparatus 100 may, in the embodiment shown, preferably include bottom panel 1, combo pulley post 10, media drive idler post 13, LCD bracket 16, tab dispenser frame support bar 22, take-up spool drive pulley 24, feeder exit guide 26, tab drive bushing 28, dispenser shaft bracket 33, clutch spring 35, 755 RW Bumpers 39, Oilite bushing with flange 41, DC power jack assembly 42, back tape mounting post 43, rear panel 47, thumb screw 61, media guides 63, 64, media feed angle adjustment bracket 65, media feed guide 66, front panel 1, separator 68, separator frame 69, rubber bumpers 70, and exit tray 71.

Referring to **FIG. 3**, when electric motor **38a** is activated, the belt **53** which is coupled, for example, at 6:1 to carrier shaft **23**, rotates the friction drive roller **60**. The wrapping of the backing paper **82** around the friction drive roller **60**, combined with the tension in the backing paper **82** being provided by the take-up spool **20** which is driven by O-ring **125**, provides a positive drive. It takes, for example, 100 degrees of rotation of 1.25 inch friction drive roller **60** to achieve the dispensing of one tab **81**, which is a pitch of about 1.1 inch. To assure proper tension in the backing paper **82** wrapped around the friction drive roller **60**, the take-up spool **20** is rotated more than one pitch. The tab peel plate **17** is a thin metal plate with a rounded edge. The action of the backing paper **82** being pulled around the radius of the edge of the tab peel plate **17** causes the tab **81** to peel from the packing paper **82** and be positioned into the media path.

As shown in **FIG. 3**, as the friction drive roller **60** is rotated and the backing paper **82** is taken up on take-up spool **20**, the tab brake roller **58** is rotated in the direction indicated by arrow **127** about axis point **126**. Once the friction drive roller **60** stops rotating, the weight of the tab brake roller **58** rotates by its own weight in the direction opposite of the direction indicated by arrow **127** and thereby rotates spindle **19**. The tab brake roller **58** is preferably rotatably attached to one end of the tab reel brake link **57** via the reel brake bar post **34**. The grooved region **155** is preferably formed adjacent the other end of the brake link **57** to receive O-ring **128** which contacts with O-ring **129** positioned in groove **175** formed adjacent the end of tab reel spindle **19**. The brake link **57** is preferably rotatably attached with, for example, a conventional fastener through opening **156** of the brake link **57** to the mounting frame **21**. The opening **156** is offset from one end of the brake link **57** to provide sufficient length, and in combination with the weight of roller **58**, sufficient force to stop the spindle **19** with tab roll **80** from rotating as the tab brake **130** returns to a first position **400** from a second position **402**, which is above the first position **400**. The weight of

the tab brake roller **58** and length of the brake link **57** are also sufficient to allow the drive motor **38a** to take-up the backing paper **82** and efficiently rotate the tab brake **130** from a first position **400** to a second position **402**. The weight of the tab brake roller **58** and length of the brake link **57** are also sufficient to rotate the spindle **19** with tab roll **80** by applying force to the backing paper **82**. Preferably, O-rings **128**, **129** contact each other when the tab brake **130** is in the first position **400** and act to brake the spindle **19**. The constant action of the tab brake **130** between positions **400** and **402** provides a constant load to the drive motor **38a**, which would otherwise be changing based on the number of tabs remaining on the roll **80**.

Referring to **FIGS. 1, 22 and 23**, a tab dispenser sensor **77** is electrically connected to the main logic board **9**, and mounted inside the housing **116** adjacent a tab dispenser sensor opening **79** formed in the top panel **130**. (See **FIG. 23**). A DC power supply **40** supplies power to the tabber apparatus **100**. The tab dispenser sensor **77** is preferably a reflective, modulated, phase locked, filtered beam optical sensor. The main logic board **9** includes a microcontroller **78** which receives a signal from the tab dispenser sensor **77** when the edge of the partially peeled tab **81** blocks the tab dispenser sensor **77**. The main logic board **9** preferably includes a motor driver **101** operatively connected to the microcontroller **78**. The main logic board **9** may also preferably include electrically erasable programmable read only memory (EEPROM) **99** operatively connected to the microcontroller **78**.

The microcontroller **78** sends a signal to the motor driver **101** that electronically deactivates or electronically brakes the motor **38a** to end the rotation of the friction drive roller **60**. Electronic braking uses electromagnetic force to slow down and turn off the motor very rapidly. The tab dispenser sensor **77** preferably uses a modulated architecture to pulse infrared LED and gate on a phototransistor only when the phototransistor detects that the pulsed source (the

tab **81**) is present. The tab dispenser sensor **77** also preferably includes a narrow band width filter to improve the signal to noise ratio, which allows the tab dispenser sensor **77** to be mounted in a position which faces ambient light sources. As shown in **FIGS. 2** and **3**, the tab dispenser sensor **77** is faced toward the partially peeled tab **81**. The tab dispenser sensor **77** detects the presence of the tab **81** when it is partially peeled, for example, 25% peeled. The remainder of the peeling action is controlled electronically. There is a time delay of, for example, 10-15 milliseconds when the motor **38a** is deactivated by a signal from the microcontroller **78**. The precise amount of peel may be programmed on (EEPROM) **99** which is operatively connected to the microcontroller **78** by a user by incrementing or decrementing, for example, in $\frac{1}{4}$ msec second intervals. The set points are indicated on a liquid crystal display (LCD) **15**. Adjustment to the tab dispensing assembly **118** may be necessary to achieve a tab centered on the open edge of the form **90**. Adjustments may be necessary or desired, for example, due to the size, shape, age or other physical characteristics of the tabs **81**, and the thickness of the form **90**.

Referring to **FIGS. 1** and **2**, a media sensor **54** is positioned beneath media sensor opening **83**. Preferably, as shown in **FIGS. 2, 3** and **23**, the media sensor **54** is positioned adjacent the media sensor opening **83** in a position upstream of the tab dispenser sensor **77**. As shown in **FIG. 23**, the feed rollers **5** are positioned in openings **230**. The drive rollers **6** connected to drive shaft **45** are positioned in openings **240**. The drive rollers **6** attached to exit shaft **44** are positioned in openings **250**, and the tab drive roller **7** is positioned in opening **200**. The media sensor **54** is also preferably a reflective, modulated, phase locked, filtered beam, optical sensor. The media sensor **54** senses the leading edge of the media feeding past a tab dispense center region, and over opening **83**. This opening **83** will be blocked from a time just prior to the time the vertical standing tab **81a** has been removed, until the trailing edge of the media clears

the opening **83** and media sensor view. During that period of time, no tab can be dispensed, because upon detection of the leading edge of the media or form **90**, the media sensor **54** sends a signal to the microcontroller **78** which electronically prevents activation of the motor **38a** until the trailing edge of the media has cleared the view of the media sensor **54**. The media sensor **54** provides the microcontroller **78** with signals so that the time gap in the unblocked state and the time gap in the blocked state can be measured.

For the embodiment shown, for example, the approximate tab dispensing rate is 65msec per tab, which is the time required to accelerate and brake the motor **38a** and tab dispensing assembly **118**. Accordingly, for this example, a minimum gap of 65msec would be required between the leading edges of adjacent media **90** to dispense each tab **81**. A pre-dispenser cycle, which occurs while the media **90** blocks the media sensor **54**, reduces this minimum gap. If the next media appears before the tab sensor is blocked, an error has occurred.

The LCD **15** is used to provide status information on the feed and tab systems. For example, a 2 line by 16 line character LCD may be used to provide a 4 digit batch counter or a six digit audit non-volatile counter. The LCD **15** provides status information on the feeder, the media and tab systems, and any error conditions. The LCD also facilitates programming of the peel adjustment.

Two momentary switches **87**, **88** allow the user to start and stop the media and tab dispenser drives. A maintained position SPST rocker switch **89** is used to control the DC power to the tabber apparatus **100**.

The media sensor **54** is positioned in front of the tab dispensing sensor **77**. Accordingly, in operation, the leading edge of the form **90** will first block the media sensor **54** for a period of time (for example, 40-50msec) before it strikes the tab **81**. The leading edge then strikes the vertically positioned tab and moves the tab **81a** away from the tab sensor **77**, causing the tab sensor **77** to become unblocked (possibly only momentarily due to reflection from the media **90** passing over the top of the tab sensor **77**).

Referring to **FIG. 6**, the waveform timing diagram for the tab sensor **200** and media sensor **202** shows an example of the sequencing of the tabbing process. The far left side of the diagram (position A) illustrates a point in time when a tab (Tab #1) is completely dispensed and is blocking tab dispensing sensor **77**. At position A, a first form (Media #1) is being fed towards Tab #1 but is not yet blocking the media sensor **54**. As Media #1 is advanced toward Tab #1, the leading edge of Media #1 blocks the media sensor (position B). At position B, the media sensor sends a signal to the microcontroller **78** which starts a delay timer, which may be included as firmware on the microcontroller **78**. After a period of time lapses, the delay timer will start the pre-dispense cycle. Media #1 continues to be advanced and pulls Tab #1 clear of the tab dispensing sensor **77** (position C). The light reflected from Media #1, however, continues to block the tab dispensing sensor **77**. Once the timer delay is completed, the pre-dispense cycle starts (position D). At position D, the microcontroller **78** sends a command signal to motor driver **101** to start the tab motor **38a**, and starts the timer for the pre-dispense cycle. The backing paper **82** is taken up through rotation of the friction drive roller **60**. Tab #2 is partially peeled from the backing paper **82** and is suspended above Media #1. Once the time sequence for the pre-dispense cycle expires, the microcontroller **78** sends a command signal to turn off or electronically brake the tab motor **38a** (position E). Media #1 unblocks both the tab sensor **77** and the media sensor **54** (position F). At position F, the sensors send signals to the microcontroller **78**, which initiates the start of Tab #2 dispense cycle, by sending a command signal to turn on tab motor **38a** and start the timer for the dispense cycle. As Tab #2 brakes the plane of the top panel **30**, the tab sensor **77** is blocked and the tab sensor **77** sends a signal to the microcontroller **78**, which sends a command signal to the motor driver **101** to shut off or electronically brake the motor **38a** (position G). At position G, Tab #2

is fully dispensed. As a second form (Media #2) is advanced toward Tab #2 the media sensor 54 is again blocked, by the leading edge of Media #2, thus starting the next cycle.

5 As shown in **FIGS. 7-10**, each of the pressure roller shafts **300**, which include the upper mid-shaft **4** and upper exit shaft **36**, preferably include a recessed area or notch **302** formed adjacent at least one end and preferably both ends of the shaft **300**, to receive a retaining member **310** (which are shown in **FIG. 2**, as retaining members **8, 52**). The retaining member **310** includes a body
10 portion **312** and arm portions **314, 315**. The arm portions **314, 315** are sized to fit through a pair of openings **305, 306** formed in both the right and left side panels **2, 3** of the frame. The retaining member **310** is preferably a thin flat member as shown, and may be made of, for example, steel or other suitable material. The arm portions **314, 315** each include an opening **316** formed
15 therein. As shown, arm portion **314** receives a locking pin **318**. An extension spring **320** may be attached at one end to the frame or panel, and at the other end to the opening **316** in arm portion **315**. Alternatively, a second locking pin **318** may be fitted in opening **316** of arm portion **315** and, the spring **320** attached to the opening in the locking pin. The spring may be attached in any other
20 suitable manner to bias the retaining member **310** against the shaft **300**. Any other means of biasing the arm portion **315** may alternatively be used. The arm portion **315**, which fits in opening **306**, may be rotated about arm **314** to allow insertion of the pressure roller shaft **300** in slot **307**. The opening **306** is preferably a slot sized to allow sufficient rotation of arm **315** for insertion of shaft
25 **300**. Accordingly, the shaft **300** is captive in all other planes except for the vertical plane where the shaft **300** may move up and down as various media thicknesses are encountered. The shaft **300** may be released if the retaining member **310** is lifted the distance of the thickest media, so that the pressure

roller shaft **300** may be displaced axially to be removed. This provides the operator with a quick way of clearing the operating area to remove any jams which may occur.

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While the embodiments of the invention disclosed herein are presently considered to be preferred, various changes and modifications can be made without departing from the spirit and scope of the invention. The scope of the invention is indicated in the appended claims , and all changes that come within the meaning and range of equivalents are intended to be embraced therein.

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